



Dart Aerospace Ltd.
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**RBW1205G00132-
3G-11**

Job Sheet 190509



Part No: RBW1205G00132-3G-11

Job Qty: 3 pcs

Part Name: Location Placard



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/11/19

Job Tracking No: SIOP

Due Date: 3/8/19

Created By: Dara Macdonald

Type: Stock

Description:

Note: DWG RBW1205G00132-3G Rev 9 IPP Rev A 18.02.13 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	3 pcs	3/8/19		0.00	1.22	Small Fab - 1		MCC
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	3 pcs	3/8/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
130	Packaging 3-1 - Stock - B4B	3 pcs	3/8/19		0.00	0.00	Packaging 3 - 1 - B4B		DAS 28 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		



Container No: S154413



Part: RBW1205G00132 - 3G - 11

Job No: 190509

Serial No/Batch: S154413

Revision: J

Inspector:

Exp Date:

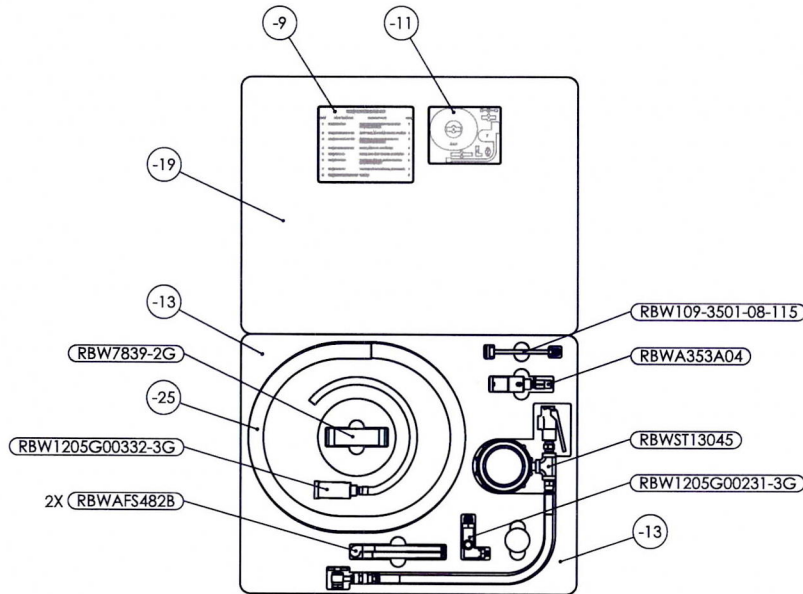
Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/16/19

					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140	QC 21 - SA	3 pcs	3/8/19	0.00 0.00	QC 21 - SA - 21	DAS FEB 19 2019
					QC 21 - SA - 70	21
					QC 21 - SA - 53	53
Part Op 110 - (Small Fab) 1-Engrave placard using Laser engraver as per DWG. Sheet 3. ***NOTE*** Use PDF Descriptions: 120 - QC5- Inspect part completeness to step on W/O 130 - Identify as per dwg & Stock Location: _____ 140 - QC21- Final Inspection - Work Order Release						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
LM922402	Plastic, Black & White	.3690 sf (.123 ea)	110-Small Fab - 1	5141808		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
110-Small Fab - 1	LM922402	0	87	0		
Part Specifications						
Specifications could not be found.						

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		ADDED -19 TOOL TOP CUSHION AND PAGE 4.	4/31/2010	WP	RW
2		ADDED RADI TO L SHAPE CUT OUT FOR BETTER FINGER ACQUISITION.	5/6/2010	WP	RW
3		DELETED -1A, -1B, -1C FROM BOTTOM CUSHION & ATTACHED TO HOSE. DELETED Ø6.00 CUTOUT FROM CENTER OF BOTTOM CUSHION. CHD DEPTH OF HOSE CUT OUT FROM 4.75 TO 3.75. CHD CENTER POST FROM Ø8.25 TO Ø8.50 TO ALLOW MORE ROOM FOR HOSES. CHD BOM 1/N -1, -3, & -5. CHD -15 FROM W/200 CASE. CORRECTED -3 P/N FROM RBW109-3501-08-115.	4/21/2011	RJC	DW
4		SHT 3 UPDATED -7 CUTOUT. SHT. 4 ADDED CUTOUTS FOR TIRE INFLATOR, REMOVED FROM BOX.	12/27/2011	JAG	
5		-11 MODIFIED PLACARD TO MATCH BOTTOM TOOL CUSHION -13 MODIFIED CUTOUT FOR TIRE INFLATOR. ADDED CUTOUT FOR -1, MOVED CUTOUTS FOR FIT.	4/25/2012	JAG	
6		CORRECTED -19 Ø1.20 HOLE CUT OUT LOCATION 180° TO FIT LID PROPERLY.	9/24/2012	RJC	SE
7		-11 MODIFIED PLACARD FOR RBW7839-2G. -13 (FOAM) MODIFIED CUTOUT Ø TO ALLOW FOR RBW7839-2G. -19 CHD PLACARD CUTOUT DEPTH WAS .07 IS .125	1/17/2013	BIM	SE
8		REDRAWN IN SOLIDWORKS. -9 CORRECTED ITEM -3 1/N WAS RBW109-351-08-115 IS RBW109-3501-08-115. ADDED -21 & -23 RIVET AND WASHER FOR PLACARD. -9 & -11 WAS B/O IS MANUFACTURED. -19 CHD LOCATION OF CUTOUT ON BACKSIDE.	10/14/2013	JAG	RW
9	17-0122	CHD DRAWING NUMBER WAS RBW1205G00131-3G IS RBW1205G00132-3G. UPDATED TO NEW STANDARD. -1 REPLACED W/ RBWA353A04. -2 REPLACED W/ RBW1205G00231-3G. -3 REPLACED W/ RBW109-3501-08-115. -4 REPLACED W/ RBW1205G00332-3G. -5 REPLACED W/ RBW7839-2G. -6 REPLACED W/ RBWAFS482B. -7 REPLACED W/ RBWST13045. -9 DELETED DIMS ARIAL SIZE 1/8, ARIAL SIZE 3/16. CHD DIM WAS (.06) IS .06. CHD TOLERANCES WAS ±.005 IS ±.010. WAS ±.01 IS ±.03. ADDED ITEM 8 TUBING TO PLACARD. -11 ADDED ITEM #8. CHD DIM WAS (.04) IS .08. CHD TOLERANCES WAS ±.005 IS ±.010. WAS ±.01 IS ±.03. -13 REDESIGNED TO FIT -25. CHD DIMS WAS Ø.50 IS Ø.100. WAS Ø.63 IS Ø.91. CHD B/O REF WAS 5.83 X 14.42 X 18.87 I.R. SPECIALTY IS 8.40 X 17.21 X 20.30 (CASE SOLUTIONS). CHD MATL WAS Y20 BLACK IS ETHAFOAM 220 BLACK. CHD TOLERANCES WAS ±.005 IS ±.010. WAS ±.01 IS ±.03. CHD DIM WAS 4X R.50 IS 10X R.50. DELETED DIM 2X R.50 Ø.50. ADDED DIM Ø.100. -18 CHD B/O REF WAS #APP-1550-E IS #APP-1610-E. -17 REPLACED W/ RB41011. -19 CHD B/O REF WAS 1.75 X 14.22 X 18.63 I.R. SPECIALTY IS 2.01 X 17.21 X 22.30 (CASE SOLUTIONS). CHD MATL WAS Y20 BLACK IS ETHAFOAM 220 BLACK. REDESIGNED TO FIT IN LARGER CASE. CHD TOLERANCES WAS ±.005 IS ±.010. WAS ±.01 IS ±.03. -25 TUBING ADDED TO BOM QTY 1.	6/19/2017	DPD	JAG

ASSY QTY	B/O	Part #	QTY.	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			1	PMC OIL FILLING QUICK DISCONNECT		RBWA353A04	1
			1	ADAPTER, M/R DAMPER OIL FILLING		RBW1205G00231-3G	1
			1	ADAPTER, L/G SHOCKSTRUTS NITROGEN CHARGE		RBW109-3501-08-115	1
			1	HOSE, MGB OIL DRAINING		RBW1205G00332-3G	1
			1	HOSE, IGB & TGB OIL DRAINING		RBW7839-2G	1
			2	WRENCH, WHEEL BRAKE RESER COVER REM/INST		RBWAFS482B	1
			1	TIRE INFLATOR GAUGE, NITROGEN		RBWST13045	1
		-9	1	CONTENTS PLACARD	PLASTIC		2
		-11	1	LOCATION PLACARD	PLASTIC		3
B/O		-13	1	BOTTOM FOAM	ETHAFOAM 220, BLACK	8.40 X 17.21 X 20.30 (CASE SOLUTIONS)	4
B/O		-15	1	CASE	PLASTIC	PELICAN #APP-1610-E	N/S
B/O		-19	1	TOP FOAM	ETHAFOAM 220, BLACK	2.01 X 17.21 X 22.30 (CASE SOLUTIONS)	5
B/O		-25	1	TUBING	PVC W/ POLYESTER BRAID	Ø3/4 I.D. X Ø1-1/32 O.D. X 10FT, DUROMETER 70A (MCMASTER-CARR #52375K36)	1
B/O			1	DART PLACARD	ALUMINUM	RB41011	N/S

NOTE:
REF. AGUSTA T/N: 3G1205G00132.

DART AEROSPACE	
TITLE HELICOPTER SERVICING KIT	
DWG NO. RBW1205G00132-3G	
REV 9	
MAT'L REAR FRONT SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES XXX ± .005 FRACTIONS ± 1/8 XX ± .01 ANGLES ± 5° X ± .1 SURFACES ± 125/ 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: PERRITT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: RJC 07/10/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: AA 07/14/2017	USED ON MODEL
QA APPR: JL 07/19/2017	AGUSTA AW139
APPROVED: JAG 07/20/2017	
SCALE 1:8	DATE 4/20/2010
SHEET 1 OF 5	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
8		-9 CORRECTED ITEM -3 T/N WAS RBW109-351-08-115 IS RBW109-3501-08-115.	10/15/2013	CFS	RW
9	17-0122	-9 DELETED DIMS ARIAL SIZE 1/8, ARIAL SIZE 3/16, CH'D DIM WAS (.06) IS .06. CH'D TOLERANCES WAS $\pm .005$ IS $\pm .010$, WAS $\pm .01$ IS $\pm .03$. ADDED ITEM 8 TUBING TO PLACARD.	6/19/2017	DPD	JAG

4X R.13

BLACK BACKGROUND W/
WHITE LINES & LETTERS

RBW1205G00132-3G				
ITEM	PART NUMBER	DESCRIPTION	QTY.	
1	RBWA353A04	QUICK DISCONNECT COUPLING PCM OIL FILLING	1	
2	RBW1205G00231-3G	ADAPTER, M/R DAMPER OIL FILLING	1	
3	RBW109-3501-08-115	ADAPTER, L/G SHOCKSTRUTS NITROGEN CHARGE	1	
4	RBW1205G00332-3G	HOSE, MGB OIL DRAINING	1	
5	RBW7839-2G	HOSE, IGB AND TGB OIL DRAINING	1	
6	RBWAFS482B	WRENCH, WHEEL BRAKE RESER COVER REMINST	2	
7	RBWST13045	TIRE INFLATOR GAUGE, NITROGEN	1	
8	RBW1205G00132-3G-25	TUBING	1	

5.00

6.25

.06

RBW1205G00132-3G		
ITEM	DESCRIPTION	QTY.
1	QUICK DISCONNECT COUPLING	1
2	ADAPTER, M/R DAMPER OIL FILLING	1
3	ADAPTER, L/G SHOCKSTRUTS	1
4	HOSE, MGB OIL DRAINING	1
5	HOSE, IGB AND TGB OIL DRAINING	1
6	WRENCH, WHEEL BRAKE RESER	2
7	TIRE INFLATOR GAUGE, NITROGEN	1
8	TUBING	1



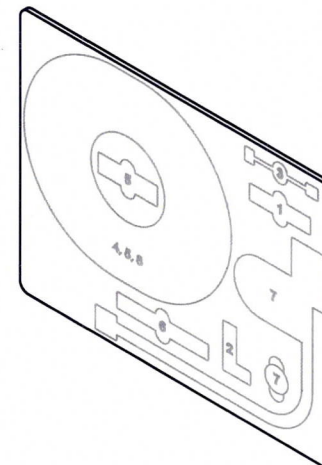
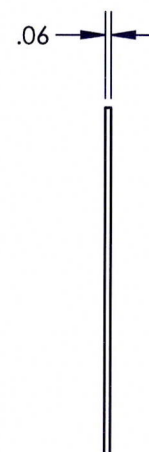
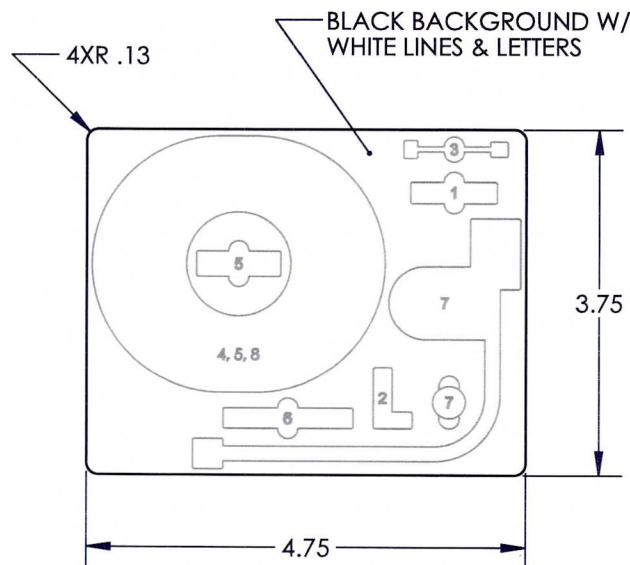
TITLE		HELICOPTER SERVICING KIT	
DWG NO.		RBW1205G00132-3G-9	
REV		9	
MATERIAL		PLASTIC	
HEAT TREAT			
FINISH			
SPEC		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX $\pm$.010 FRACTIONS $\pm$ 1/8 .XX $\pm$.03 ANGLES $\pm$ 1° .X $\pm$.1 SURFACES = 125/✓	
DRAWN BY:		SMITH	
CHECKED:		RJC 07/10/2017	
OPPS APPR:		AA 07/14/2017	
QA APPR:		JL 07/19/2017	
APPROVED:		JAG 07/20/2017	
SCALE		1:2	
DATE		10/14/2013	
SHEET		2 OF 5	

(-9)

CONTENTS PLACARD

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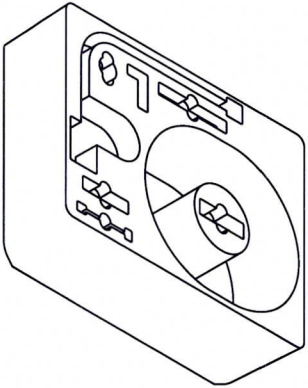
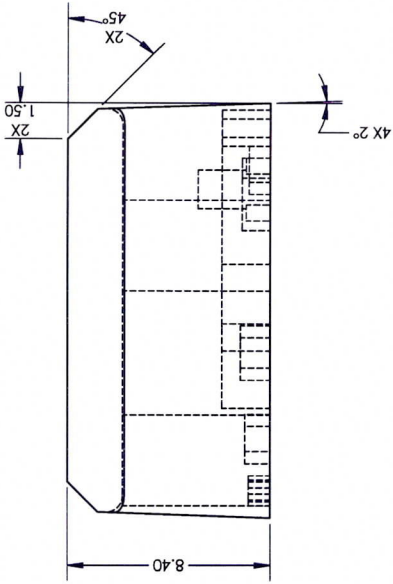
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
9	17-0122	-11 ADDED ITEM #8. CH'D DIM WAS (.06) IS .06. CH'D TOLERANCES WAS $\pm .005$ IS $\pm .010$, WAS $\pm .01$ IS $\pm .03$.	6/19/2017	DPD	JAG



(-11)

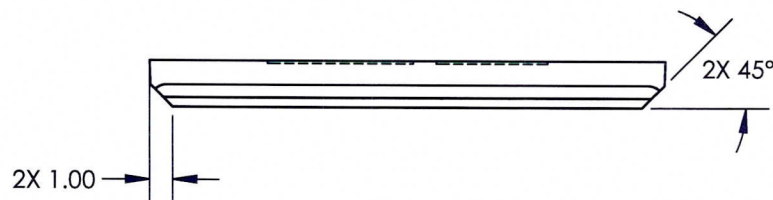
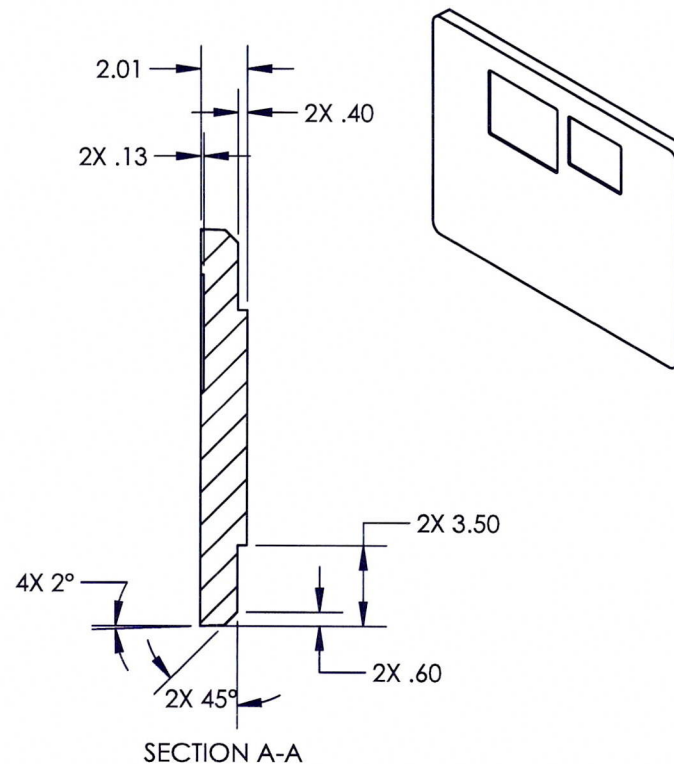
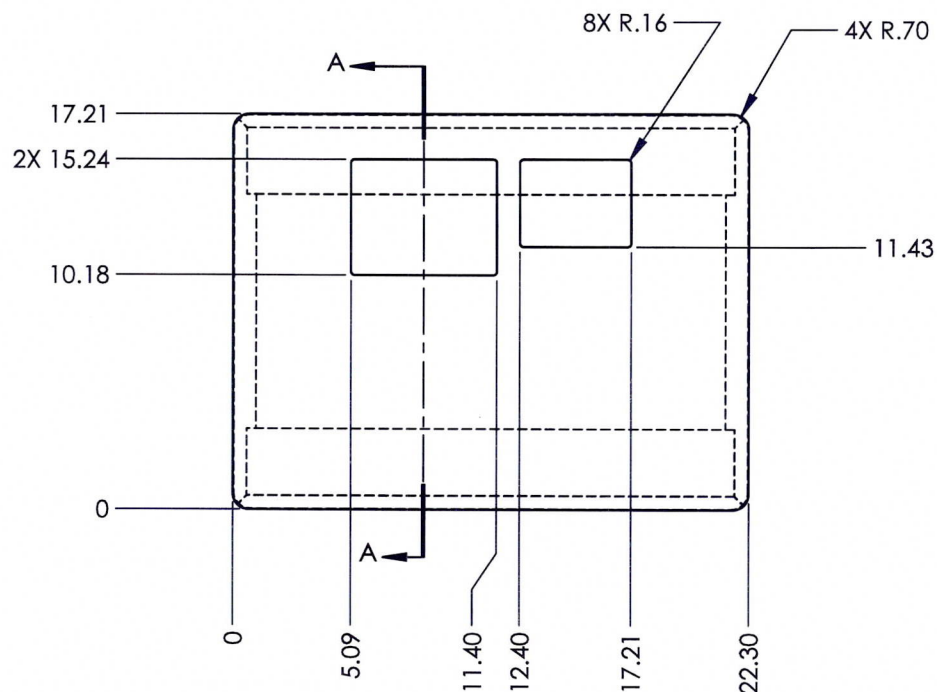
LOCATION PLACARD

DART AEROSPACE	
TITLE HELICOPTER SERVICING KIT	
DWG NO. RBW1205G00132-3G-11	REV 9
MAT'L PLASTIC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX $\pm$.010 FRACTIONS $\pm$ 1/8
FINISH	.XX $\pm$.03 ANGLES $\pm$ 1°
SPEC	.X $\pm$.1 SURFACES = 125°
DRAWN BY: SMITH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: RJC 07/10/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 07/14/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 07/19/2017	USED ON MODEL
APPROVED: JAG 07/20/2017	AGUSTA AW139
SCALE 1:2	DATE 10/14/2013 SHEET 3 OF 5

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
9	17-0122	-19 REDESIGNED TO FIT IN LARGER CASE. CH'D TOLERANCES WAS $\pm .005$ IS $\pm .010$, WAS $\pm .01$ IS $\pm .03$. CH'D B/O REF WAS 1.73 X 14.22 X 18.63 I.R. SPECIALTY IS 2.01 X 17.21 X 22.30 (CASE SOLUTIONS). CH'D MAT'L WAS Y20 BLACK IS ETHAFOAM 220 BLACK.	6/19/2017	DPD	JAG



(-19)
TOP FOAM

DART AEROSPACE	
TITLE HELICOPTER SERVICING KIT	
DWG NO. RBW1205G00132-3G-19	REV 9
MAT'L ETHAFOAM 220, BLACK	
FINISH UNTREATED	
SPEC UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX $\pm .010$ FRACTIONS $\pm 1/8$.XX $\pm .03$ ANGLES $\pm 1^\circ$.X $\pm .1$ SURFACES = 125/	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: PERRITT	
CHECKED: RJC 07/10/2017	
OPPS APPR: AA 07/14/2017	
QA APPR: JL 07/19/2017	
APPROVED: JAG 07/20/2017	
USED ON MODEL AGUSTA AW139	
SCALE 1:8	DATE 4/20/2010
SHEET 5 OF 5	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					